Work Order ID 85307 *85307*

June-05-12 3:34:04 PM

Item ID:	D3704-3	**Accept**	*N900040100*
Revision ID:		**Setup Start**	*NS1*
Item Name:	Escutcheon	**Stop**	*NS2*

Start Date:	05/06/2012	**Start Qty:** 2.00	*2*	**Cust Item ID:**
Required Date:	19/06/2012	**Req'd Qty:** 2.00	*2*	**Customer:**
Reference:				

Run Start *NR1*
Stop *NR2*

Approvals:	**Process Plan:** MLJ	**Date:** 12/06/05	**Tooling:**	**Date:**
	QC:	**Date:**	**SPC (Y/N):**	**Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3704	**Revision Nbr** B								
100 *100* Bandsaw	**Memo**	0.00 0.00				ST	12-06-07		(x2)
Jeaspa Bandsaw	CUT 3.25" LONG								
110 *110* HAAS 1	**Memo**	0.00 0.00				ST	12-06-11		(x2)
HAAS CNC vertical machine #1	MILL AS PER DWG AND FOLIO FA807 DWG REV: B FOLIO REV: 4A DEBURR								

Dart Aerospace Ltd

W/O: 85307	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3704-3 PAR #: ______ Fault Category: Machining NCR: (Yes) No DQA: [signature] Date: 12/06/27

Resolution: use-as-is Disposition: use-as-is QA: N/C Closed: [signature] Date: 12/6/27

NCR: 12-1513	WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action	Section B			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
12/6/12	110	Radius around base of latch housing is too deep. Approx 0.010.	[initials] 12/06/12	Acceptable. Sufficient mat'l to not affect strength. Buff transition so to be less noticeable.	[signature]	B.A 12/06/12	[initials] 12/6/12	[initials] 12/6/12

NOTE: Date & initial all entries

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Work Order ID 85307

June-05-12 3:34:04 PM

85307

Item ID: D3704-3

Revision ID:

Item Name: Escutcheon

Accept *N900040100*

Setup **Start** *NS1*

Stop *NS2*

Start Date: 05/06/2012 **Start Qty:** 2.00 *2*

Required Date: 19/06/2012 **Req'd Qty:** 2.00 *2*

Cust Item ID:

Customer:

Reference:

Run **Start** *NR1*

Stop *NR2*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00				ET	12-06-11		(x2)
130 *130* QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00	D.A. 12/06/12			2	∅		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 **Memo**	0.00 0.00				2	HG	12-6-12	

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Work Order ID 85307

June-05-12 3:34:04 PM

85307

Item ID:	D3704-3	**Accept**	*N900040100*
Revision ID:		**Setup**	**Start** *NS1*
Item Name:	Escutcheon		**Stop** *NS2*

Start Date: 05/06/2012 **Start Qty:** 2.00 *2* **Cust Item ID:**

Required Date: 19/06/2012 **Req'd Qty:** 2.00 *2* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150 QC Quality Control	**Memo**	0.00				2			12/06/13
160	Identify as per dwg & Stock Location: 5 5 6 1	0.00							
160 Packaging Packaging	**Memo**	0.00				2			12/06/13
170	QC21- Final Inspection - Work Order Release	0.00							12/6/14
170 QC Quality Control	**Memo**	0.00							

MLJ 12/06/13

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W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

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Picklist Print

June-05-12 3:34:09 PM

Work Order ID: 85307 *85307*

Parent Item: D3704-3 *D3704-3*

Parent Item Name: Escutcheon

Start Date: 05/06/2012 **Required Date:** 19/06/2012

Start Qty: 2.00 **Required Qty:** 2.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.250		Purchased	No				f	9.8570		0.52			

M6061T6B1 500X01 250 ** ZT 12-06-09

6061-T6 Bar 1.50 x 1.25

Location	Loc Qty	Loc Code	
MAT003	9.857		
118071	0.112		
119513	0.945		
121660	8.8		.52

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** _____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DART AEROSPACE LTD	Work Order:	85307
Description: Escutcheon	Part Number:	D3704-3
Inspection Dwg: D3704 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] [ ]

Drawing Dimension		Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.22	+/-0.030	1.222	✓		vern	RT-4
0.610	+/-0.010	.610	✓		vern	
Ø0.170	+0.005/-0.001	.170	✓		vern	
Ø0.322 x 100°	+/-0.010 x +/-0.5°	.332	✓		vern	
1.063	+/-0.010	1.056	✓		"	
2.125	+/-0.010	2.130	✓		"	
1.054	+/-0.010	1.049	✓		"	
0.206	+/-0.010	.206	✓		"	
Ø0.440	+0.005/-0.001	.441	✓		"	
0.90	+/-0.030	.891	✓		"	
0.500	+/-0.010	.505	✓		"	
0.125	+/-0.010	.132	✓		"	
R0.06	+/-0.030	.060	✓		rad gauge	
0.625	+/-0.010	.627	✓		vern	RT-4
R0.156	+/-0.010	.156	✓		rad gauge	
R0.03	+/-0.030	.030	✓		"	
0.03 x 45°	+/-0.030 x +/-0.5°	.060	✓		vern	RT-4
Ø0.755	0.005/-0.001	.755	✓		"	
0.175	+/-0.010	.169	✓		depth gauge	RT-6
0.218	+/-0.010	.218	✓		vern	RT-4
0.435	+/-0.010	.428	✓		"	
0.220	+/-0.010	.215	✓		"	
0.06 x 45°	+/-0.030 x +/-0.5°	.040	✓		"	
Ø0.686	0.008/-0.001	.6855	✓		"	
Ø0.628	0.008/-0.001	.627	✓		"	
0.685	+/-0.010	.680	✓		"	
			—		"	

Measured by:	RT
Date:	12 06 11

Audited by:	D.A
Date:	12/06/12

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.02.02	New Issue	KJ	

.085
.2205

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

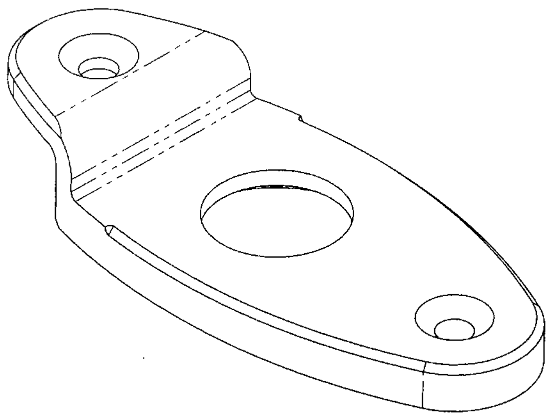
Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

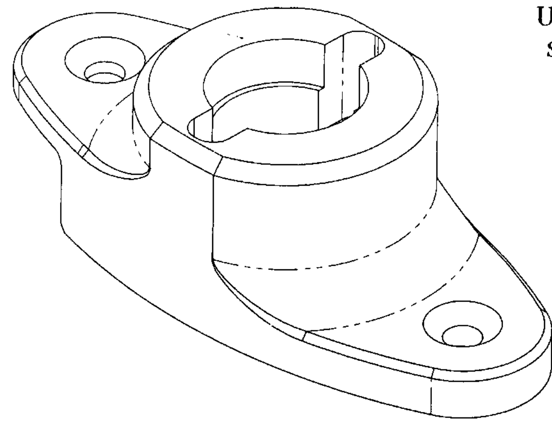
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85307 MLJ
12/06/05



D3704-1 ESCUTCHEON



B **D3704-3 ESCUTCHEON**

RELEASED 09/04/09

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3704-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT:
- D3704-1 = 0.04 lbs
- D3704-3 = 0.11 lbs

REV.	DESCRIPTION	BY	DATE
B	ADDED D3704-3. REASON: COMPATIBILITY WITH AAI'S HANDLE.	MB	09.03.17
A	NEW ISSUE	MB	08.02.05

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3704 — REV. B — SHEET 1 OF 3
MFG. APPR.		
APPROVED		TITLE ESCUTCHEON — SCALE NTS
DE APPR.		
DATE	09.03.17	

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

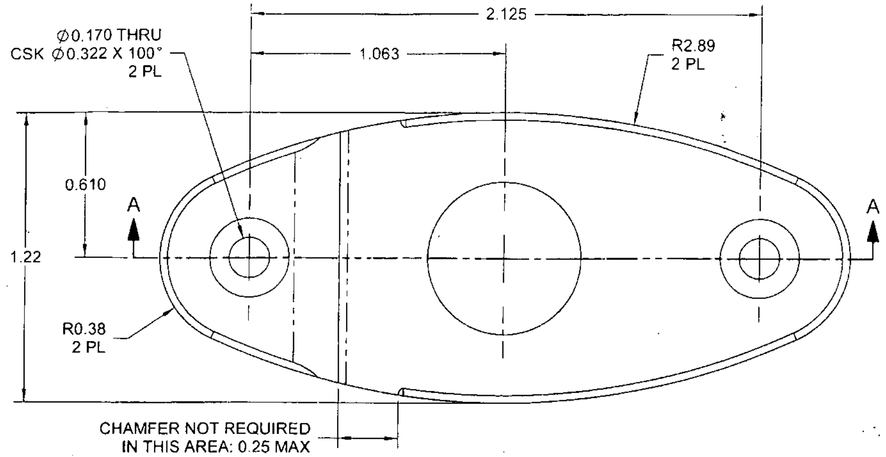
Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

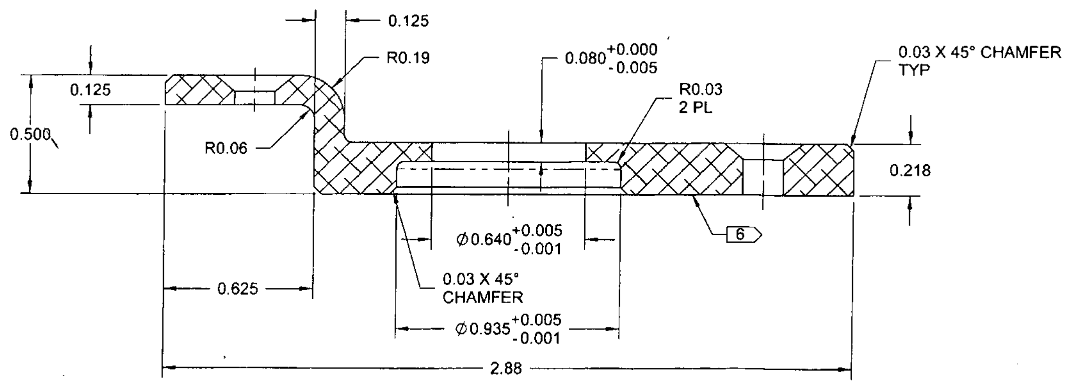
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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D3704-1 ESCUTCHEON



SECTION A-A

RELEASED 09/04/09

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. D3704	REV. B SHEET 2 OF 3
MFG. APPR.			
APPROVED		TITLE ESCUTCHEON	SCALE NTS
DE APPR.			
DATE	09.03.17	COPYRIGHT © 2008 BY DART AEROSPACE LTD	

Dart Aerospace Ltd

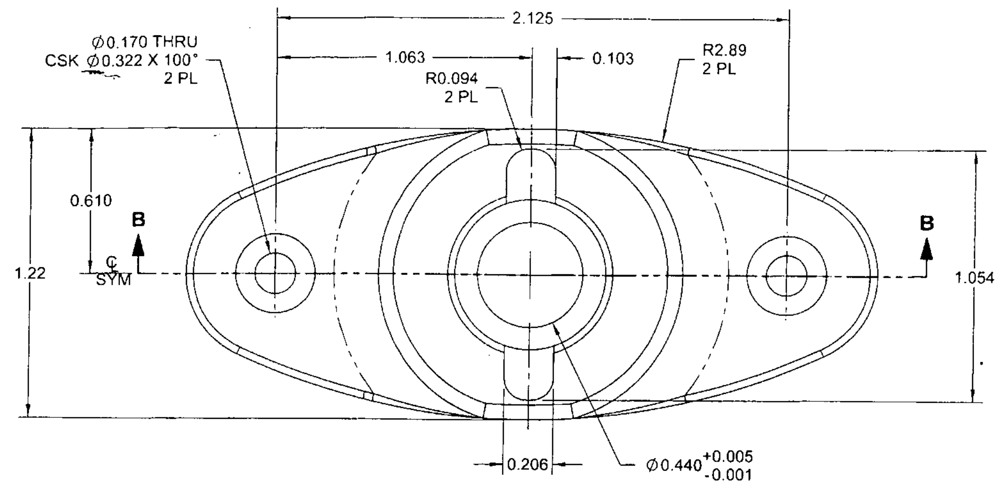
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

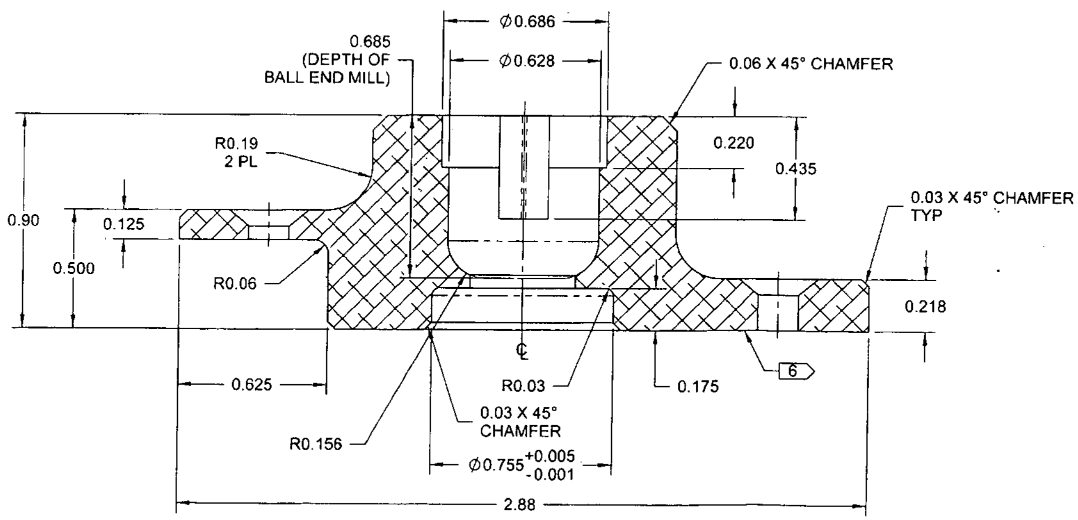
Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



B D3704-3 ESCUTCHEON



SECTION B-B

es307

RELEASED 09/04/09

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3704 — REV. B — SHEET 3 OF 3
MFG. APPR.		
APPROVED		TITLE: ESCUTCHEON — SCALE: NTS
DE APPR.		
DATE	09.03.17	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries